

Work Order ID 57234

March 30, 2010 6:16:48 PM



Page 2

Item ID: D4082-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Bracket

Stop



Start Date: 30/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
Number

10-04-01

Draw
Rev.

0.00

Plan
Code

0.00

Accept
Qty

0.00

Reject
Qty

0.00

Reject
Number

2

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

131



Small Fab

Small Fab

Prill AS per Day
using DT8560

0.00

0.00

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

132

QC5- Inspect part completeness to step on W/O



QC

Quality Control

Memo

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

S10401

0.00

X2

140

Chemical Conversion Coat per QSI005 4.1



HandFinish

Hand Finishing

Memo

0.00

m-f 10/04/01

0.00

QX

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum



Powdercoat

Powder Coating

Memo

0.00

m-f 10/04/01

0.00

QX

M113170

overTemp : 320⁰F

Start Time : 2:10

Finish Time : 2:40

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Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

10-4-15P (2E)

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

10-4-1 (2E) SL

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/07 HJ

MF 10-4-6

Picklist Print

March 30, 2010 2:08:22 PM

Page 1

Work Order ID: 57234



Parent Item: D4082-1



Parent Item Name: Mounting Bracket

Start Date: 30/03/2010

Required Date: 31/03/2010

Comments: IPP REV:A NEW ISSUE 10-03-30 JLM VERIFIED BY:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X12.00 0	16-50	Purchased	No			100	f	6.6206	9.1225			



6061-T6 Bar 1.00 x 12.00

15.00 102-000
10.03.30

Good
Batch
This Only

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT05	6.6206	
104719	2.5	
106701	4.1206	

B33680

10-03-30

33680 X 0

DART AEROSPACE LTD		Work Order: 57Q34
Description: mounting bracket		Part Number: A4082-1
Inspection Dwg: A4082	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.13	$\pm .030$					
Ø.257	$\pm .006$ -.001	.258	✓			
.38	$\pm .030$.38	✓			
1.076	$\pm .010$	1.076	✓			
6.72	$\pm .030$	6.730	✓			
1.985	$\pm .010$	1.985	✓			
.440	$\pm .010$.440	✓			
.25	$\pm .030$.250	✓			
4.00	$\pm .030$					
9.372	$\pm .010$	9.372	✓			
13.848	$\pm .010$					
Ø.191	$\pm .005$ -.001	.191	✓			
1.035	$\pm .010$	1.035	✓			
.500	$\pm .010$.501	✓			
2.776	$\pm .010$	2.776	✓			
8.00	$\pm .030$	8.001	✓			
7.546	$\pm .010$	7.546	✓			
1.000	$\pm .010$	1.001	✓			
3.290	$\pm .030$	3.285	✓			
3.11	$\pm .030$	3.108	✓			
.250	$\pm .010$.253	✓			
4.720	$\pm .010$	4.716	✓			
6.37	$\pm .030$	6.370	✓			

Measured by:	JL	Audited by:		Prototype Approval:	N/A
Date:	10.04.01	Date:	10.04.01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	57234
Description: MOUNTING BKLT.	Part Number:	D4082-1
Inspection Dwg: D4082 Rev: A		Page 1 of 1

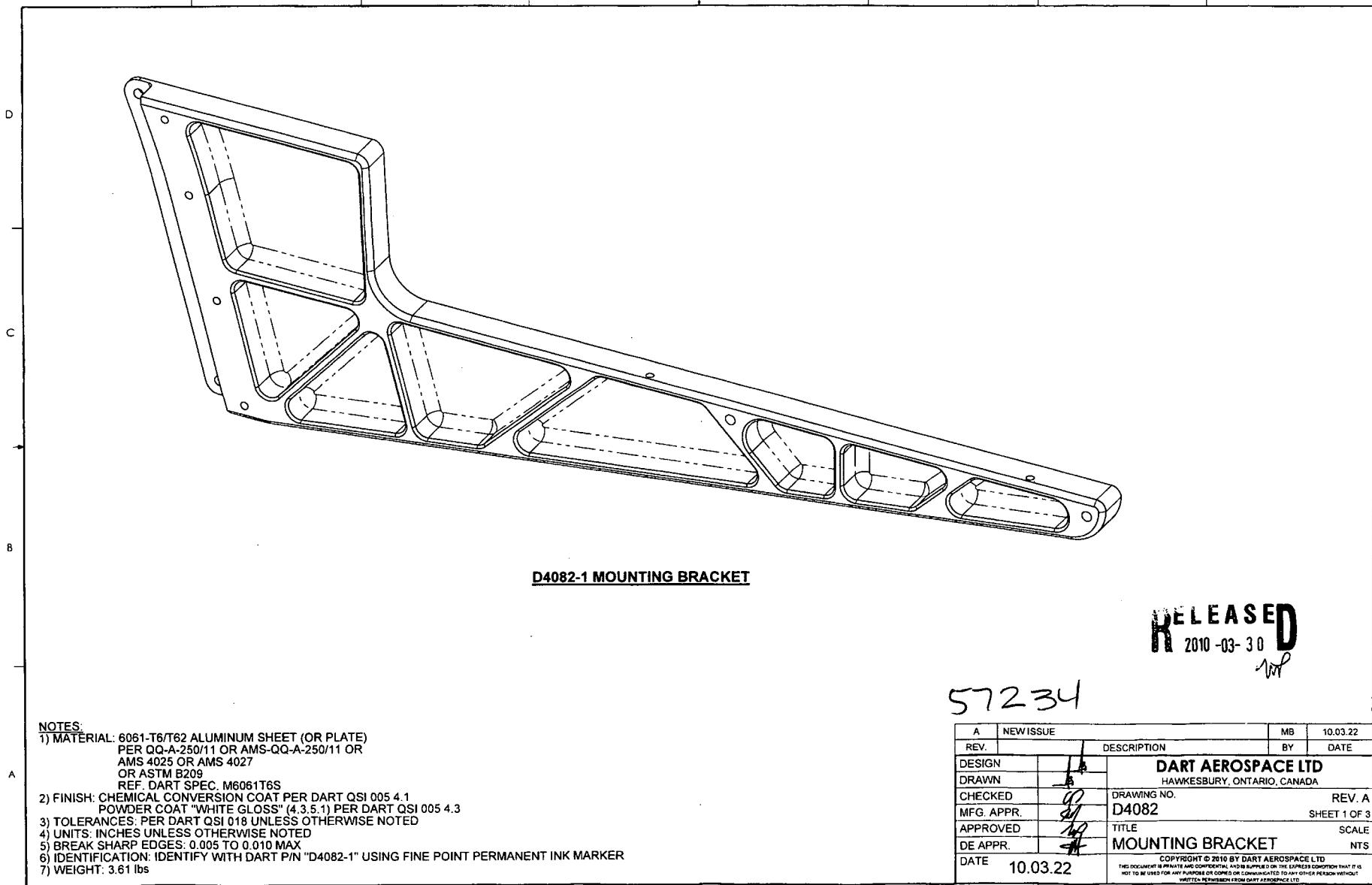
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>JL</i>	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	10/04/01	Date:	10.04.01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



NOTES
 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET (OR PLATE)
 PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR
 AMS 4025 OR AMS 4027
 OR ASTM B209
 REF. DART SPEC. M6061T6S

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

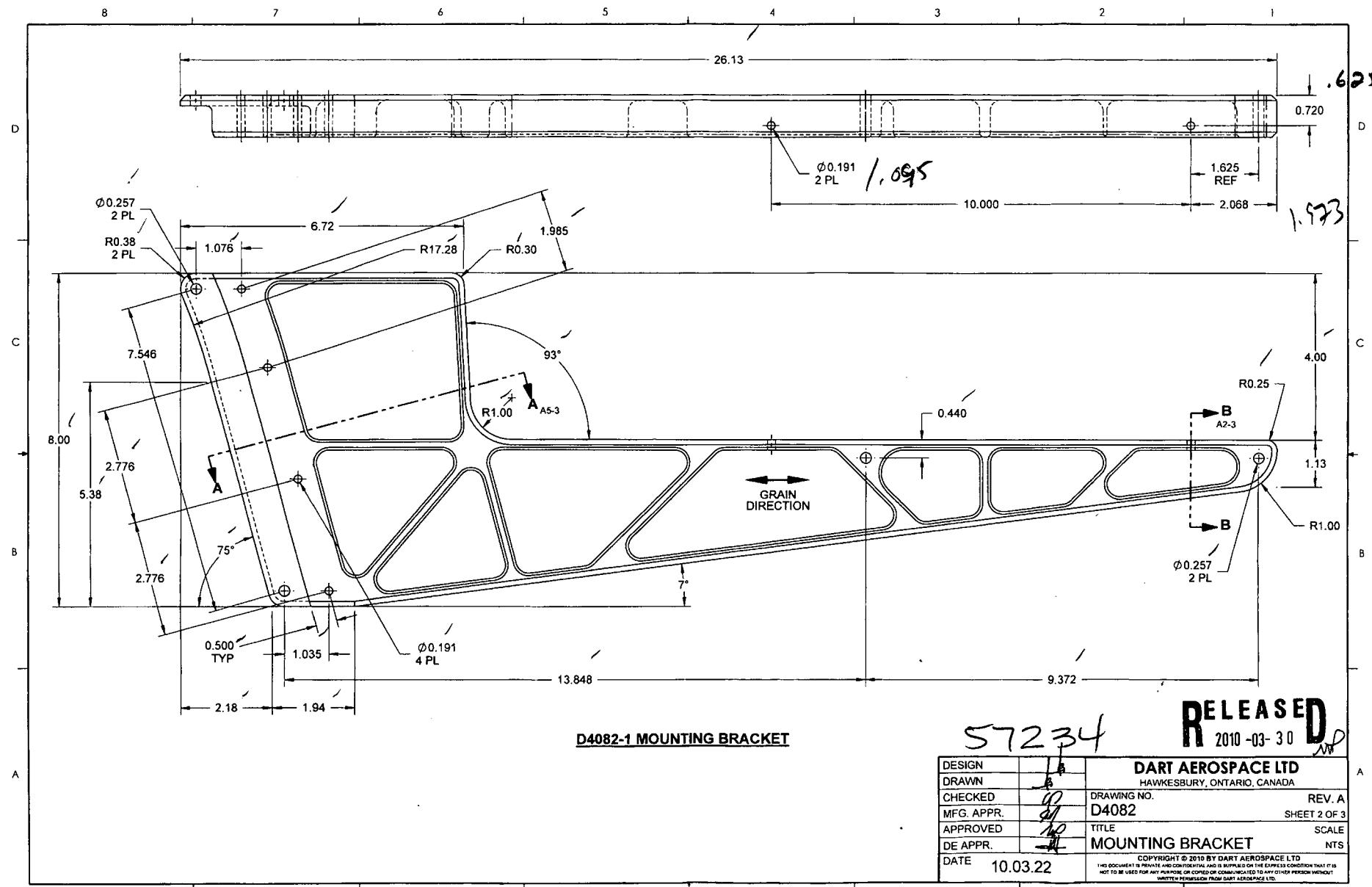
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4082-1" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 3.61 lbs

8 7 6 5 4 3 2 1



D4082-1 MOUNTING BRACKET

57234

RELEASED
2010-03-30

2010 -03- 30

DESIGN	<u>14</u>	DART AEROSPACE LTD		
DRAWN	<u>13</u>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<u>89</u>	DRAWING NO.	REV. A	
MFG. APPR.	<u>89</u>	D4082	SHEET 2 OF 3	
APPROVED	<u>140</u>	TITLE	SCALE	
DE APPR.	<u>141</u>	Mounting Bracket	NTS	
DATE	10.03.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
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